

DUPLICATE

Dart Aerospace Ltd.

Date: Friday, 6/1/2007 1:02:30 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 32738		
Estimate Number	: 12786		
P.O. Number	: NIA	Part Number	: D35645
This Issue	: 6/1/2007	S.O. No.	: NIA
Prsht Rev.	: NC	Drawing Number	: D3564 UNDER REVIEW
First Issue	: NIA	Project Number	: N/A
Previous Run	: 31420	Drawing Revision	: A/B C PH 07.07.12
		Material	: NIA
		Due Date	: 6/8/2007
Written By	:	Qty:	20 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-03-08 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 1.1099 sf(s)/Unit Total: 22.1970 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: ~~M103961~~ M103961 M101873

HB 07-07-19

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3564

Dwg Rev: C

Prog Rev: C

*** (D3564-SF) *** PH 07.07.12

HB 07-07-19

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 07-07-19

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAV 07/07/19



5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT 3155 and DT 3179

Form Joggle as per Dwg D3564 on brake using Jig DT

SAV 07/07/19



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/07/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/03	5	Toggle was made by error						

NOTE: Date & initial all entries

Date: Friday, 6/1/2007 1:02:30 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32738

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

En 07/07/20 ^{counter} (23)

7.0

POWDER COATING

POWDER COATING



M 104846



(23x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-L 07/07/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M 07/07/21



(23)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(23x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-14

M-L 07/07/23

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(23)

Comment: FINAL INSPECTION/W/O RELEASE

R 07/07/23

Job Completion



U 07-07-23

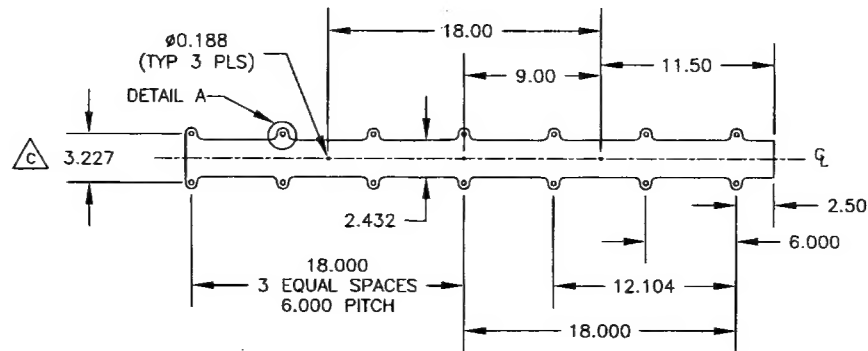
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

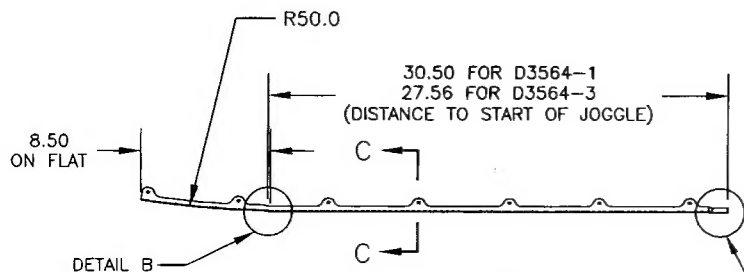
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

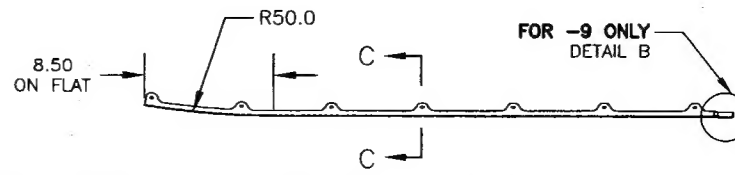
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

FOR -1 ONLY
DETAIL B

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

RELEASED
07-06-28-11

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

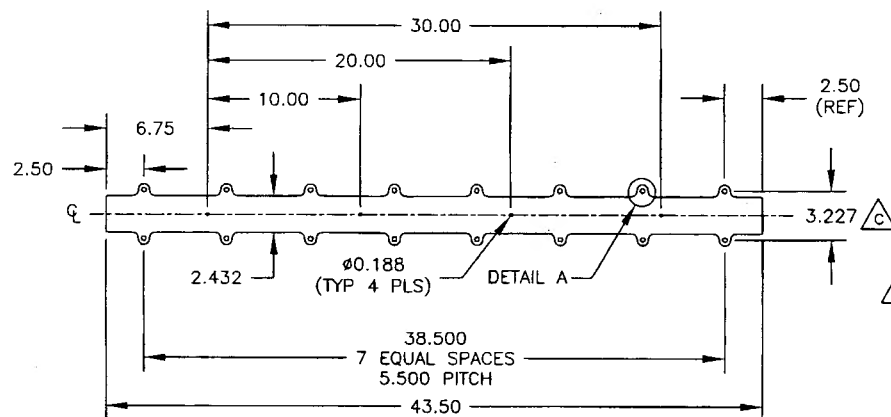
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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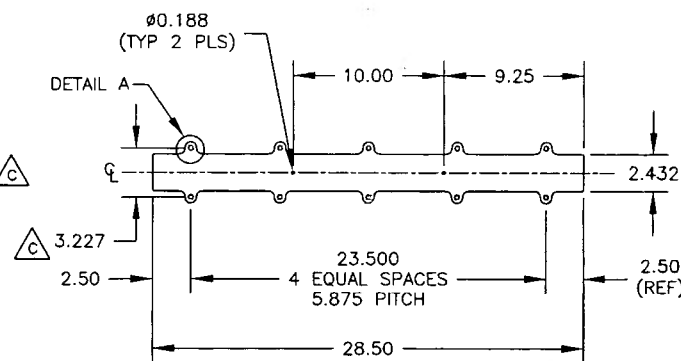
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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3564
DATE	07.04.17	TITLE WEARSHOE
		REV. C SHEET 1 OF 2 SCALE 1:8

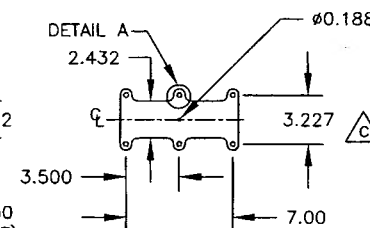
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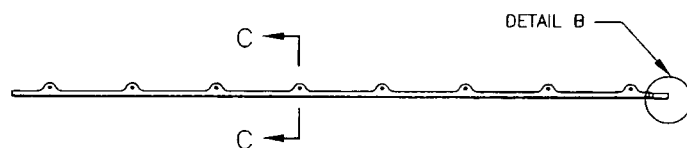
D3564-5F FLAT PATTERN



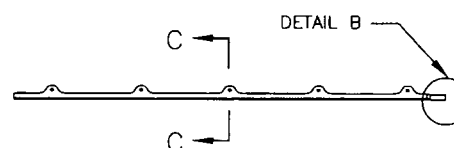
D3564-7F FLAT PATTERN



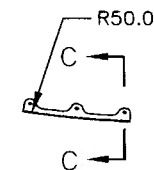
D3564-13F FLAT PATTERN



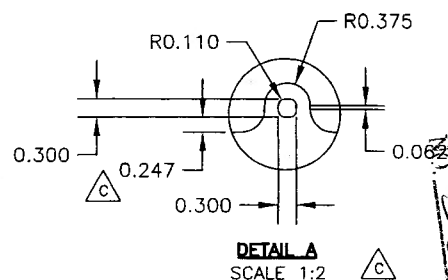
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



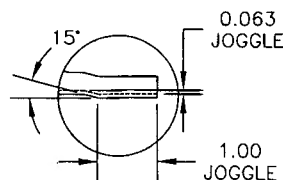
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



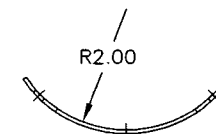
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07.04.17

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DATE		D3564	REV. C
07.04.17		TITLE	SHEET 2 OF 2
		WEARSHOE	SCALE 1:8

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